

Date: Thursday, 5/4/2006 11:09:36 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HI-STEP LEG ASSEMBLY
 Job Number : 26928
 Estimate Number : 10385
 P.O. Number : NIA Part Number : D3065041
 This Issue : 5/4/2006 S.O. No. : NIA Drawing Number : D3065 REV A2
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : SMALL /MED FAB Drawing Revision : A2
 Previous Run : 26452 Material : NIA
 Written By : *See Comment Below* Due Date : 5/15/2006 Qty: 60 Um: Each
 Checked & Approved By : *06.05.05*
 Comment : Est Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 26928A STEP SPACER



Comment: Sub-Component STEP SPACER

2.0 26928B STEP SPACER



Comment: Sub-Component STEP SPACER

3.0 26928C STEP LEG



Comment: Sub-Component STEP LEG

4.0 26928D STEP SPACER



Comment: Sub-Component STEP SPACER

5.0 D30651 Step Spacer



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Step Spacer

Pick:

Qty	Part Number	Description	Batch
1	D3065-1	Spacer	B26928A

6.0 D30653 Step Spacer



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Step Spacer

Pick:

Qty	Part Number	Description	Batch
1	D3065-3	Spacer	B26928B

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/07/12	10	Put back in stock 1 D 3065 - 1 B2628A pieces 1 D 3065 - 7 D26211D 2 pieces 1 D 3065 - 3 B2628B 9 pieces	SB	06/07/12	1		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Date: 06/07/12
QA: N/C Closed: _____ Date: _____

NCR: N/A		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/07/12	10	2 D 3065 - 7 were scrap due out of dimension 1 D 3067-1 was scrap		Scrap + destroy	SB 06/07/12	 06/07/13		

NOTE: Date & initial all entries

Date:- Thursday, 5/4/2006 11:09:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 26928

Part Number: D3065041

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D30655

Step Leg



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Step Leg

Pick:

Qty Part Number

Description

Batch

2 D3065-5

Leg

B 26928C

8.0

D30657

Step Spacer



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Step Spacer

Pick:

Qty Part Number

Description

Batch

1 D3065-7

Spacer

B 26211D

9.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 30.0000 Each(s)/Unit Total : 1800.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part Number

Description

Batch

30 MS20470AD4-4

Rivet

M100651

SAD 06/07/12

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

SAD 06/07/12

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/07/12

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA19, 18, 17

P.E. 06-07-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/4/2006 11:09:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 26928

Part Number: D3065041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

106.07-17

Job Completion



U 06.07.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

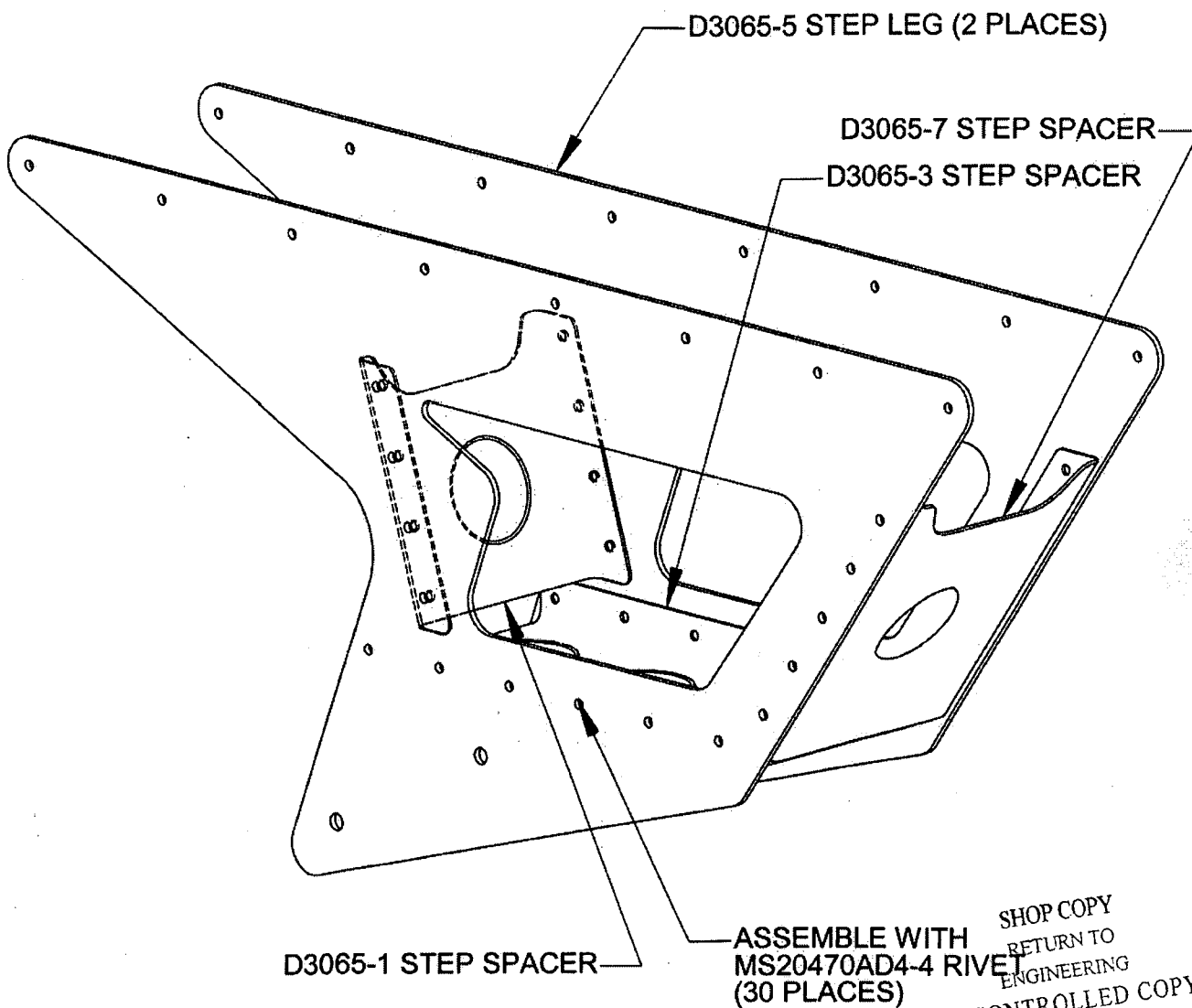
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DP	DRAWN BY	DP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D3065	REV. A
DATE 02.09.11		TITLE STEP LEG ASSEMBLY			SHEET 1 OF 5 SCALE 1:2
A	02.09.11	NEW ISSUE			
A1	03.02.13	UP	ADD SLOTS TO D3065-5		
A2	03.02.27	UP	0.551 WAS 0.410		

RELEASED
02.09.20 #



D3065-041 STEP LEG ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26928

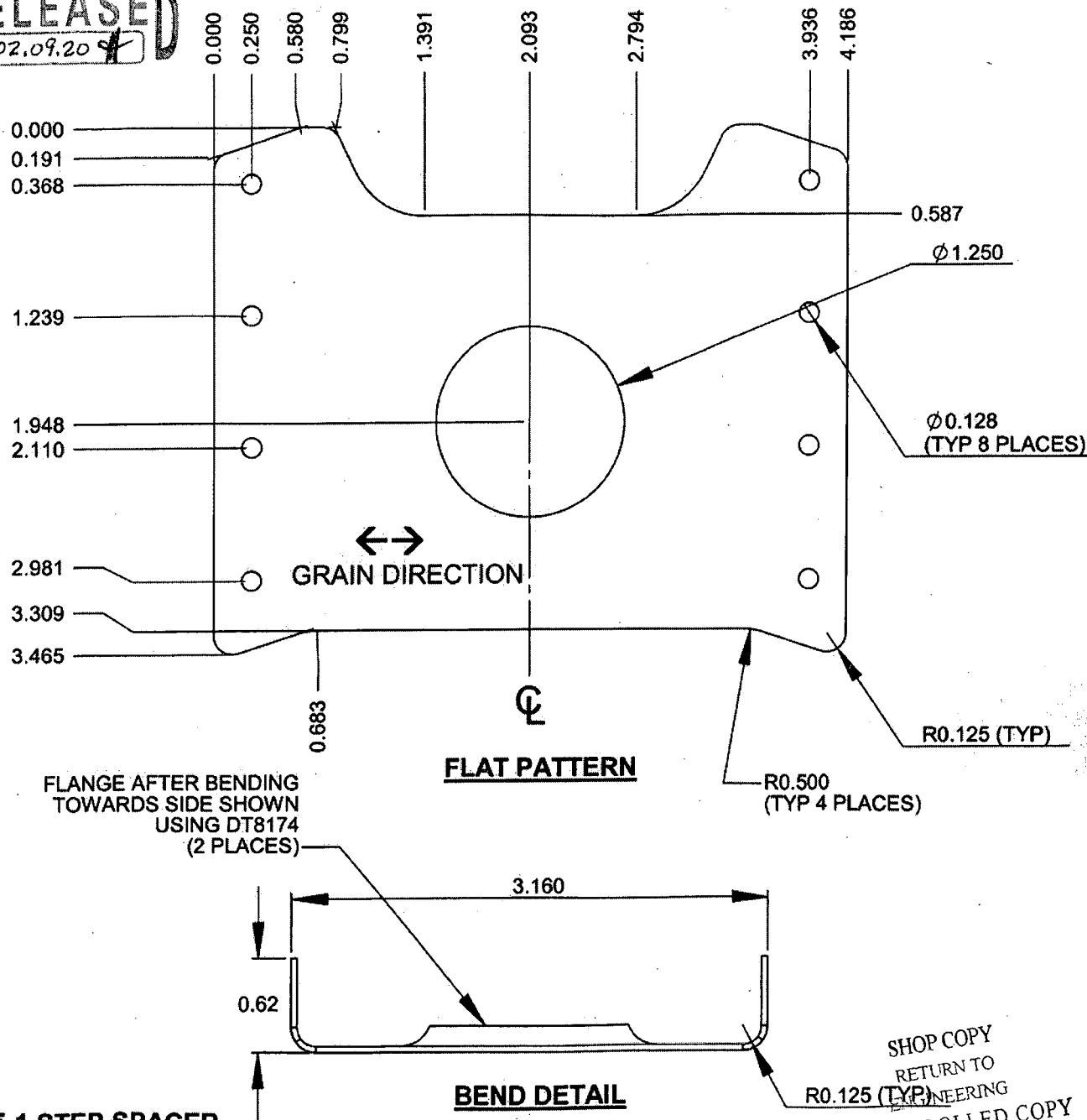
COPYRIGHT © 2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. A SHEET 2 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1

RELEASED
02.09.20



D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S 040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 26928

COPYRIGHT © 2009 BY DART AEROSPACE LTD.

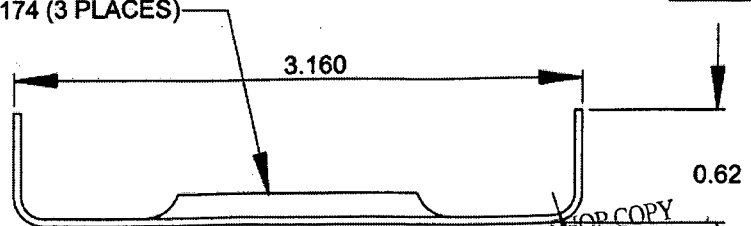
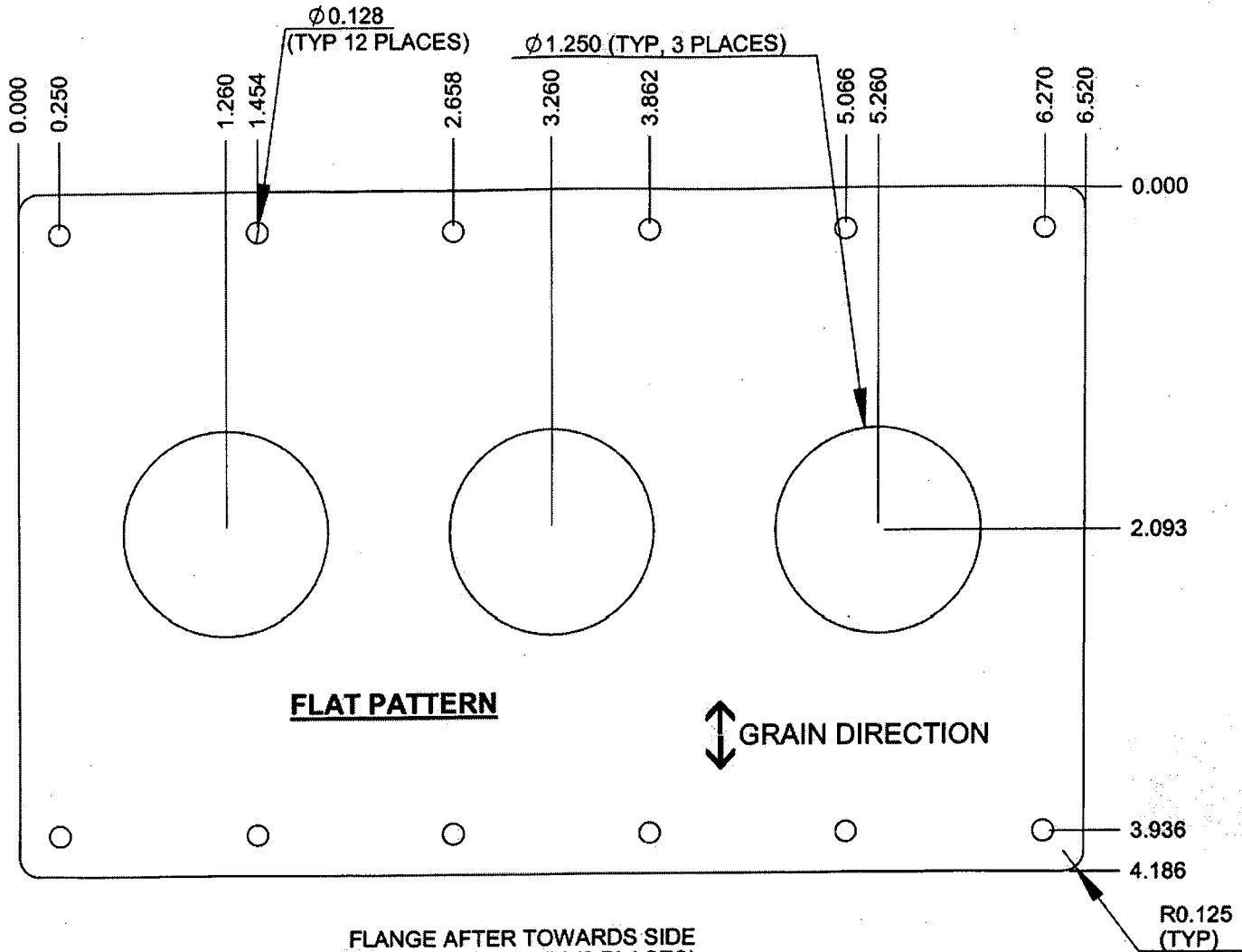
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

RELEASED
02.09.20

DART



DESIGN UP	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3065	REV. A SHEET 3 OF 5
DATE 02.09.11	TITLE STEP LEG ASSEMBLY		SCALE 1:1



D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26928

COPYRIGHT © 2002 BY DART AEROSPACE LTD.

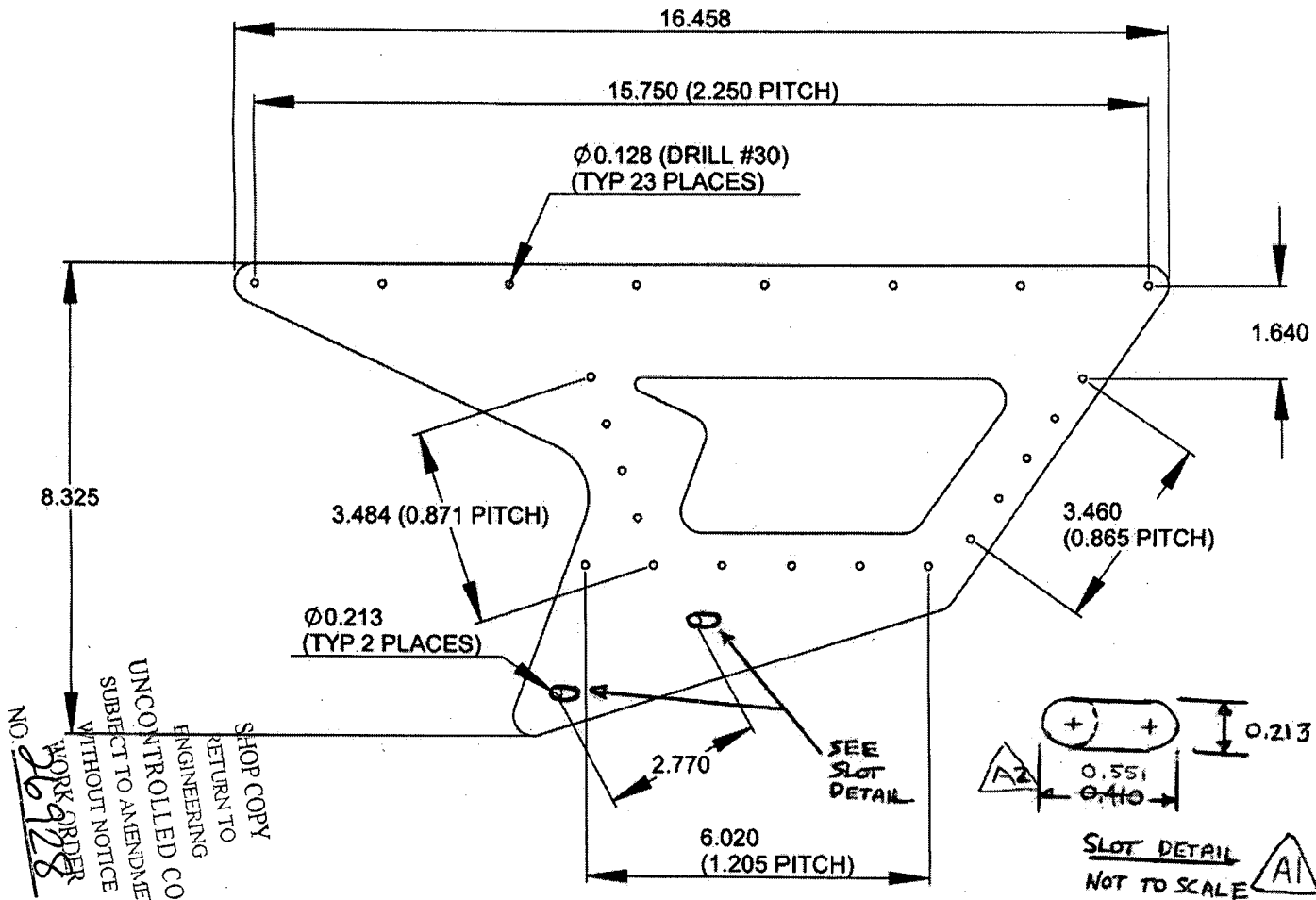
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAMMESBURY, ONTARIO, CANADA
CHECKED	✓	APPROVED	✓	DRAWING NO. D3065
DATE	02.09.11	TITLE	STEP LEG ASSEMBLY	REV. A SHEET 4 OF 5
				SCALE 1:3

RELEASED
02.09.20



D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRF"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080) OR 6061-T6
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

COPYRIGHT ©2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

